

Work Order ID 64447

Monday, December 06, 2010 10:20:00 AM



Page 1

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 12/6/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-12-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3793

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 040

1-Cut as per Dwg D3793

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 10-12-7

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-12-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Solrlos

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 64447

Monday, December 06, 2010 10:20:00 AM

Page 2

Item ID:	D3793-3	Accept		Setup	Start	
Revisor ID:					Stop	
Item Name:	Wearshoe					
Start Date:	12/6/2010	Start Qty:	12.00	Cust Item ID:		
Required Date:	12/13/2010	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(12)			
Brake NC	Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs	0.00							SB 10/12/03
140  QC	QC5- Inspect part completeness to step on W/O	0.00				(12)			
Quality Control	Memo	0.00							81012100
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				12			BL 10-12-9
Powder Coating	Memo START TIME: 8:00 OVEN TEMPERATURE: 320° FINISH TIME: 8:30	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64447

Monday, December 06, 2010 10:20:00 AM



Page 3

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 12/6/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

*ML**10/12/09**12**φ*

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location

FP-18

0.00



Packaging

Memo

0.00

Packaging

12 BL 10-12-9.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/12/14**PS 10-129*
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:20:04 AM

Page 1

Work Order ID: 64447

Parent Item: D3793-3

Parent Item Name: Wearshoe






Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	60.1900	1.2828 	16.20379			
											10-12-7		
304/316 .040 Sheet													

Location

Loc Qty

Loc Code

MAT	56.6	
115762	10.2	
115953	46.4	
MAT20	3.59	
113062	1.398	
115440	2.192	

115983

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64447
Description: Wearshoe		Part Number: D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

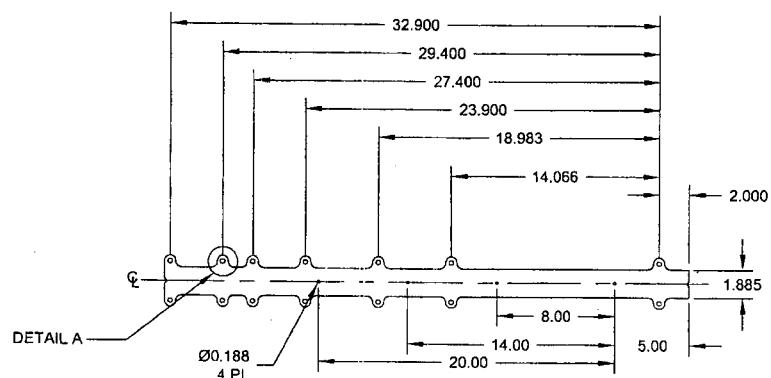
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.190	*		V IB02	
0.300 x 0.300	+/-0.010	300X303	*		V	
1.885	+/-0.010	1.888	*		V	
4.389	+/-0.010	4.386	*		V	
6.547	+/-0.010	6.544	*		V	
6.00	+/-0.030	6.00	*		T IB01	
6.75	+/-0.030	6.75	*		T	
2.000	+/-0.010	2.000	*		V	
4.750	+/-0.010	4.750	*		T	
9.500	+/-0.010	9.500	*		T	
14.250	+/-0.010	14.250	*		T	
17.750	+/-0.010	17.750	*		T	
26.735	+/-0.010	26.735	*		T	
Ø0.531 x 0.780	+0.008/-0.001	533X.781	*		V	

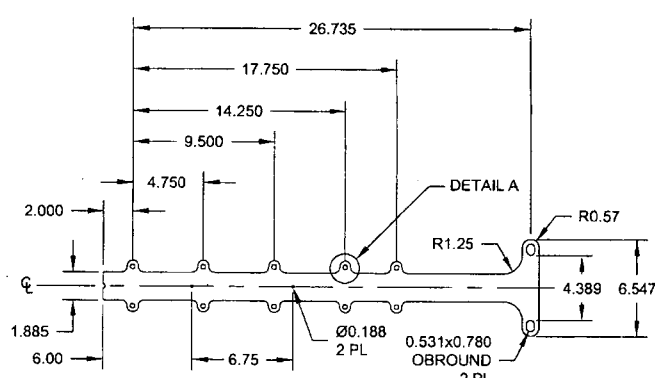
Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-12-7	Date: 10/12/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

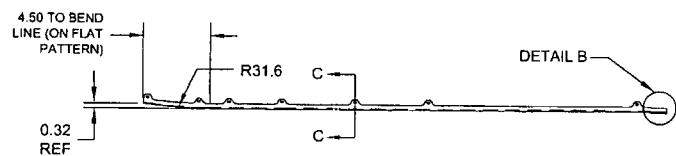
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

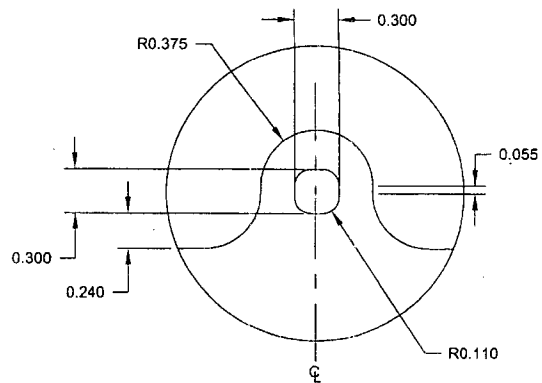
#64447

RELEASED
28.05.23/18

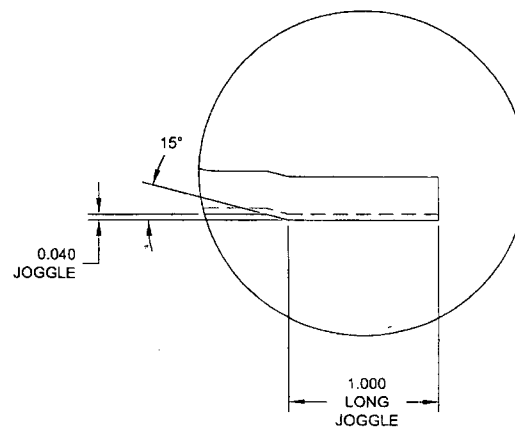
- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
 - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A		NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC			
DRAWN	PH	PORT HADLOCK, WA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.	JS	D3793	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.	JS	WEARSHOE	NTS		
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC			
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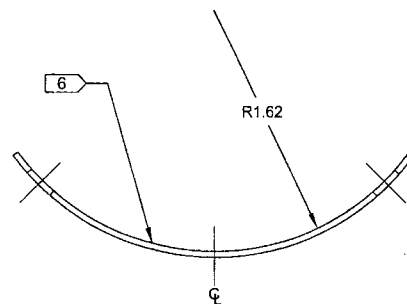
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

#64447

RELEASED
08-05-23 174

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1